



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5380-3

Job Sheet 179833



Part No: D5380-3

Job Qty: 2 ea **6 ea**

Part Name: Support Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 7/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 3 IPP Rev: A New issue JFS 16/02/03 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea		7/31/18	0.00	0.00	Start Up Machining-4		<i>mm</i>
100	CNC Vertical Machining	2 pcs		7/31/18	0.00	2.86	HAAS1-2		<i>mm</i>
110	QC	2 pcs		7/31/18	0.00	0.00	QC2 Machining-4		<i>mm</i>
120	QC	2 pcs		7/31/18	0.00	0.00	QC8 Machining-4		<i>mm</i>
121	QC	2 pcs		7/31/18	0.00	0.00	QC5		<i>mm</i>
130	Packaging	2 pcs		7/31/18	0.00	0.00	Packaging3-2		<i>mm</i>
140	QC21-SA	2 Ea		7/31/18	0.00	0.00	QC21		<i>mm</i>

Part Op 100 - Machine as per Folio FB460

Descriptions: 130 - LOCATION : LG054 **CH 56**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-3TRN 5069313 x3.	Support Base Turning Detail	1 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-3TRN	1	3	0

Part Specifications

Specifications could not be found.



Control No: S096765



Part: D5380-3
Job No: 179833
Serial No/Batch: S096765
Revision: C
Inspector:
Exp Date:
Instructions: Various STC's

Plex 6/22/18 11:32 AM dart.lacelle.linda
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	
Description: Support Base		Part Number:	D5380-3
Inspection Dwg: D5380 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.900	3.900	3.900	3.900	3.896
AB	0.256	0.263		.2560	.2560	.2560	.2560	.2560
AC	3.540	3.560		3.543	3.546	3.546	3.547	3.542
AD	1.765	1.785		1.774	1.774	1.773	1.770	1.771
AE	0.590	0.610		.599	.594	.594	.598	.598
AF	1.140	1.160		1.154	1.155	1.154	1.152	1.153
AG	2.290	2.310		2.301	2.300	2.297	2.298	2.297
AH	0.490	0.510		.497	.496	.497	.497	.498
AI	0.115	0.135		.124	.124	.124	.124	.124
AJ	0.240	0.260		.248	.249	.248	.248	.249
AK	0.140	0.160		.150	.150	.150	.150	.150
AL	1.502	1.522		1.522	1.522	1.522	1.522	1.522
AM	0.100	0.125		.120	.119	.120	.119	.120
AN	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AO	0.220	0.280		.250 R	.250 R	.250 R	.250 R	.250 R
AP	0.220	0.280		.250 R	.250 R	.250 R	.250 R	.250 R
AQ	0.170	0.230		.200	.200	.200	.200	.200
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:	<i>M.M.</i>	Date:	<i>2014/07/26</i>
Audited by:	<i>SM/ML</i>	Date:	<i>16/08/08</i>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Support Base		Part Number:	D5380-3
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	2	3	4	5
HAAS Section								
AA	3.890	3910		3.896				
AB	0.256	0.263		.2560				
AC	3.540	3.560		3.546				
AD	1.765	1.785		1.772				
AE	0.590	0.610		.596				
AF	1.140	1.160		1.152				
AG	2.290	2.310		2.297				
AH	0.490	0.510		.498				
AI	0.115	0.135		.124				
AJ	0.240	0.260		.248				
AK	0.140	0.160		.150				
AL	1.502	1.522		1.522				
AM	0.100	0.125		.118				
AN	0.053	0.073		.063 R				
AO	0.220	0.280		.250 R				
AP	0.220	0.280		.250 R				
AQ	0.170	0.230		.200				
AR								
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AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:	<i>mm</i>	Date:	2018/07/26
Audited by:	<i>mm</i>	Date:	2018/08/08
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	